

# Work Order ID 92945

November-12-12 1:34:51 PM

**\*92945\***

Page 1

Item ID: D4634-045  
 Revision ID:  
 Item Name: Aft. Center Ceiling Panel Assembly  
 Start Date: 12/11/2012 Start Qty: 2.00  
 Required Date: 12/12/2012 Req'd Qty: 2.00  
 Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
 Stop **\*NS2\***

Cust Item ID:  
 Customer:

*\*2\*-1*  
*\*2\*-1*

Approvals: Process Plan: *MCS* Date: *12-11-12* Tooling: Date:  
 QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	PA3 <i>A G M</i>								<i>EB 12/04/10</i>
100		0.00							
<b>*100*</b>									
HandThermo	Memo	0.00							<i>PTO</i>
Hand Finishing Thermoforming	Pick Kit								
110		0.00							
<b>*110*</b>									<i>DAS 07 2-83</i>
Small Fab	Memo	0.00							<i>12/04/25</i>
Small Fab	1- Assemble as per Dwg D4634-045								
	2- install No Smoking & seat belt symbols								
	3- Install led lights								
	4- Install Air valves								
	5-Install Wiring Harness								
	5-Install wiring harness								

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: adh Date: 13/05/22QA Closed: OK Date: 13/5/15

Work Order: <u>92945</u>	<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D4634-045</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>
NCR No. <u>13-2410</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input checked="" type="checkbox"/>				Found when installing D4728-049 Light + wire harness that it doesn't allow to have enough fit between Double + Parallel. Re-Design.	GP 13/4/25	cut out of Double Material to allow wire + contact to pass.  - Same cross-section so no effect on strength. d13/4/25	DL 13/4/25	S 13/05/24	DAS 16 9-83  13/04/25
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete
	<input type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Maintenance
	<input type="checkbox"/> Mislabelled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Offset
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Ovalized
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

# Work Order ID 92945

November-12-12 1:34:51 PM

**\*92945\***

Page 2

Item ID: D4634-045  
 Revision ID:  
 Item Name: Aft, Center Ceiling Panel Assembly  
 Start Date: 12/11/2012 Start Qty: 2.00  
 Required Date: 12/12/2012 Req'd Qty: 2.00  
 Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:  
 QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC6- Inspect dimensions to drawing 0.00

**\*120\***

QC Memo 0.00

Quality Control

130 Identify as per dwg & Stock Location: 0.00

**\*130\***

Packaging Memo 0.00

Packaging

140 QC21- Final Inspection - Work Order Release 0.00

**\*140\***

QC Memo 0.00

Quality Control

*8/16/25*

*11/9/492*

*13/4/26*

*13/5/3*  
*MF*  
*13-4-26*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Picklist Print

November-12-12 1:34:54 PM

Page 1

Work Order ID: 92945

\*92945\*

Parent Item: D4634-045

\*D4634-045\*

Parent Item Name: Aft. Center Ceiling Panel Assembly

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 12/08/09 New Issue DL  
12/11/08 Doc release DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>D4634-5</del> <b>D4634-145</b> <i>Wh</i>		Manufactured	No	<b>B98235</b>		100	Each	0.0000	1	2			<i>Wh</i>
<del>*D4634-5*</del>									**				<i>13/04/25</i>
Aft. Center Ceiling Panel													
D4638-1		Manufactured	No			100	Each	0.0000	1	2			
<b>*D4638-1*</b>									**				<i>13/04/25</i>
LED Light													
D4645-1		Manufactured	No	<b>B92966</b>		100	Each	0.0000	1	2			<i>13/04/25</i>
<b>*D4645-1*</b>									**				<i>13/04/25</i>
No Smoking & Fasten Belt Symbols													
D4646-1		Manufactured	No	<b>B95949</b>		100	Each	0.0000	2	4			<i>13/04/25</i>
<b>*D4646-1*</b>									**				<i>13/04/25</i>
Plenum Cap Assembly													
D4647-1		Manufactured	No	<b>B92968</b>		100	Each	1.0000	1	2			<i>13/04/25</i>
<del>*D4647-1*</del>									**				
Doubler													
<i>N/A Wh</i>													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ENG		1								
			89033		1								
D4647-3		Manufactured	No			100	Each	4.0000	2	4			
<b>*D4647-3*</b>									**				
Angle													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			Eagle		4								
			89662		4								

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Picklist Print

November-12-12 1:34:54 PM

Page 2

Work Order ID: 92945

\*92945\*

Parent Item: D4634-045

\*D4634-045\*

Parent Item Name: Aft. Center Ceiling Panel Assembly

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

D4652-1	Manufactured	No	100	Each	0.0000	2	4	
*D4652-1*						**	2	
Air Valve, 1.16 ID Disk Type								
D4664-5	Manufactured	No	100	Each	0.0000	6	12	
*D4664-5*						**		
Spacer								
D4694-045	Manufactured	No	100	Each	0.0000	1	2	
*D4694-045*						**		
Aft Channel Assembly								
D4694-047	Manufactured	No	100	Each	0.0000	1	2	
*D4694-047*						**		
Aft Channel Assembly								
D4728-049	Manufactured	No	100	Each	0.0000	1	2	
*D4728-049*						**		
Advisory Light, Aft								
D4728-055	Manufactured	No	100	Each	0.0000	1	2	
*D4728-055*						**		
Cabin Lights #3								
D4732-17	Manufactured	No	100	Each	0.0000	1	2	
*D4732-17*						**		
Label								
D4732-23	Manufactured	No	100	Each	0.0000	1	2	
*D4732-23*						**		
Label								
D4732-27	Manufactured	No	100	Each	0.0000	1	2	
*D4732-27*						**		
Label								

November-12-12 1:34:54 PM

Shop Packet Print

Page 2

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		



# Picklist Print

November-12-12 1:34:54 PM

Page 3

Work Order ID: 92945

Parent Item: D4634-045

Parent Item Name: Aft. Center Ceiling Panel Assembly

\*92945\*

\*D4634-045\*

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

MPNY-750S-9-C

Purchased No

100

Each

0.0000

7

14

~~\*MPNY-750S-9-C\*~~

N/A

\*\*

Mounting Pad

MS20426AD3-3

Purchased No

100

Each

19,402.75

4

8

~~\*MS20426AD3-3\*~~

N/A

\*\*

Rivet

Location

Loc Qty

Loc Code

ST316

1470

119109

282

121011

771

19099

417

ST333

6250

123352

6250

ST334

11682.75

122814

11682.75

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Picklist Print

November-12-12 1:34:54 PM

Page 4

Work Order ID: 92945

Parent Item: D4634-045

Parent Item Name: Aft. Center Ceiling Panel Assembly

**\*92945\***

**\*D4634-045\***

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

MS21059L3

Purchased

No

100

Each

227.0000

2

4

~~\*MS21059L3\*~~

\*\*

Nut Plate

N/A

Location

Loc Qty

Loc Code

302

10

121185

10

314

3

122452

3

ST301

28

118614

8

119546

20

ST302

124

120308

13

120833

1

121444

100

121524

10

ST316

62

122814

62

MS24694-S5

Purchased

No

100

Each

565.0000

2

4

**\*MS24694-S5\***

\*\*

Screw

(2)

OK,  
12/04/25

Location

Loc Qty

Loc Code

ST289

565

18949

129

19073

436

PLT1.5M-M

Purchased

No

100

Each

0.0000

7

14

**\*PI T1 5M-M\***

\*\*

Tie Wrap

124363

(7)

OK,  
12/04/25

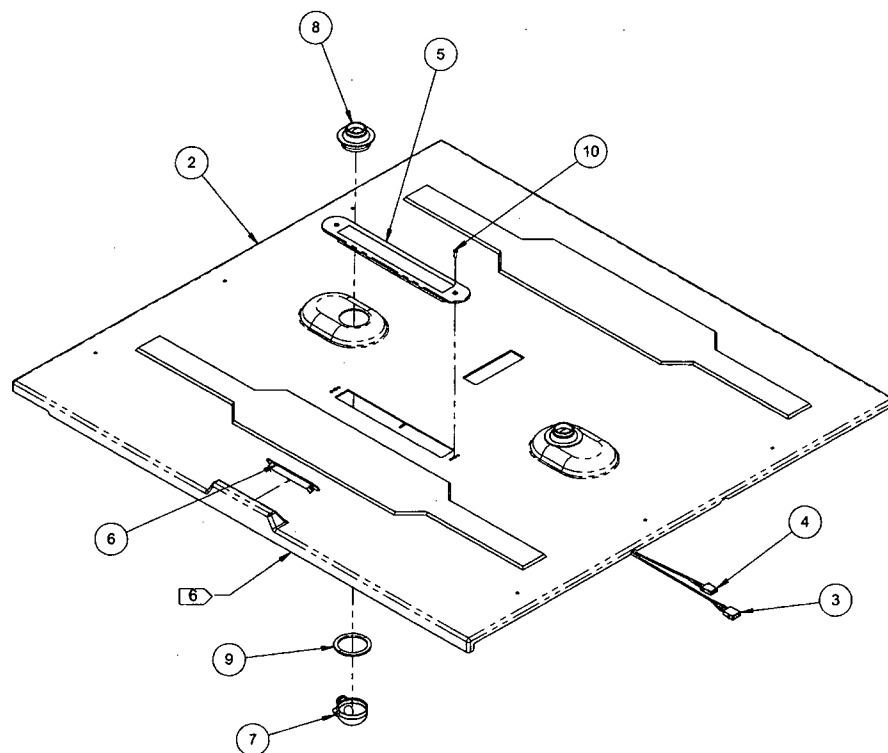
NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		



ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
4	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

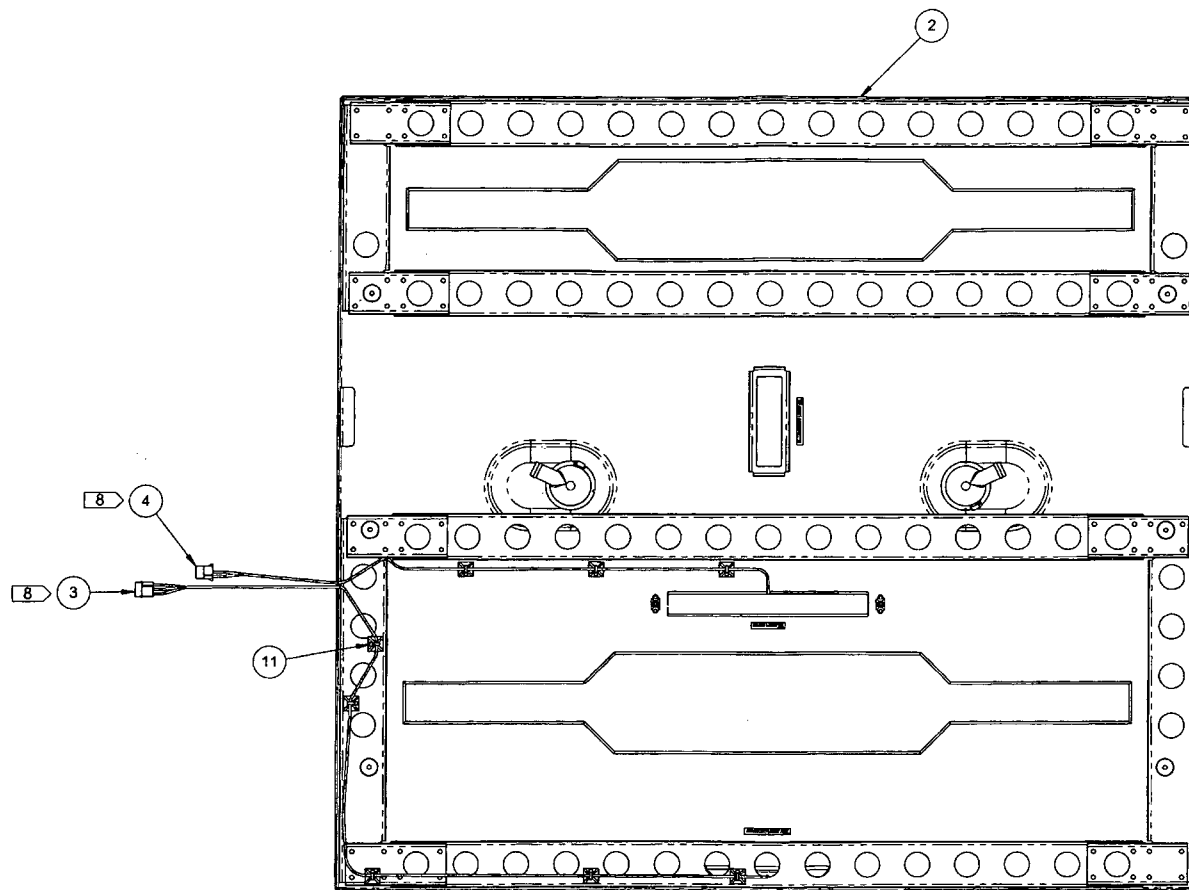
**D4634-045 AFT, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.0 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

**RELEASED**  
2013-01-30  
MP

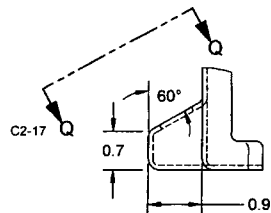
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. B
MFG. APPR.	RF		SHEET 5 OF 17
APPROVED	RF	TITLE <b>CENTER CEILING PANELS</b>	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
DATE	12.11.30	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



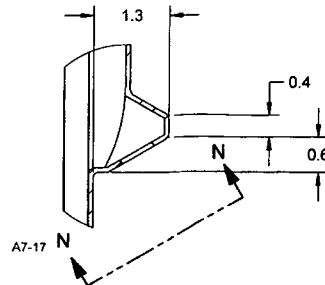
**D4634-045 AFT, CENTER CEILING PANEL ASSY**  
AUXILIARY VIEW

RECEIVED  
2013-01-30

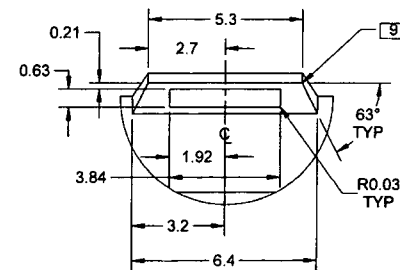
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D4634</b>	REV. B
MFG. APPR.	RF	SHEET 6 OF 17	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>CENTER CEILING PANELS</b>	NTS
DATE	12.11.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



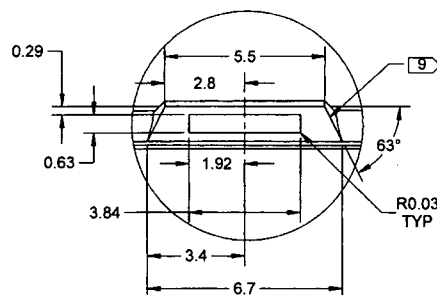
**DETAIL P** B3-14  
SCALE 2X



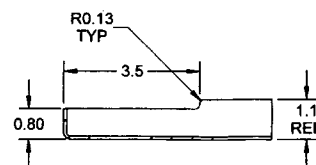
**DETAIL M** C3-10  
SCALE 2X



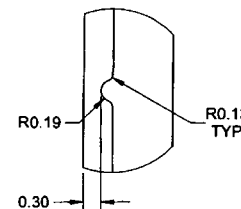
**DETAIL Q** B4-15  
SCALE 0.5X D8-17



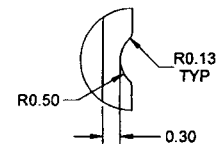
**DETAIL N** C5-17  
SCALE 0.5X B4-15



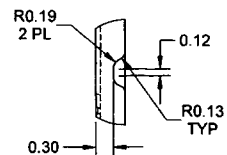
**SECTION O-O** B6-14  
SCALE 1.3X



**DETAIL R** B3-10  
SCALE 4X C3-10  
B2-12



**DETAIL S** B3-10  
SCALE 4X C2-12



**DETAIL T** C2-14  
SCALE 4X

RELEASED  
2013-01-30

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4634</b>	SHEET 17 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CENTER CEILING PANELS</b>	NTS
DATE	12.11.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## Kim Johnston

---

**From:** Linda Lacelle  
**Sent:** Monday, April 29, 2013 10:18 AM  
**To:** Kim Johnston  
**Cc:** Patrick Smith  
**Subject:** FW: D4634-045 for 139 interior

Kim, please scan this with the D139-816-011 kit Thx LL

-----Original Message-----

**From:** Patrick Smith  
**Sent:** April-29-13 10:09 AM  
**To:** Eric Downing  
**Cc:** Chris Provencal; Daryl Leger; Linda Lacelle  
**Subject:** RE: D4634-045 for 139 interior

Linda,

We had the incorrect wire harness in that location, 3312-P2 which arrived from Eagle incorrectly pinned, we used the harness from the first set of panels.

D4728-049 batch B93455.

Pat

-----Original Message-----

**From:** Patrick Smith  
**Sent:** April-26-13 9:57 AM  
**To:** Eric Downing; Linda Lacelle  
**Cc:** Chris Provencal; Daryl Leger  
**Subject:** RE: D4634-045 for 139 interior

Linda,

I spoke to Chris and the wire is not dangling at the last ty-wrap location, but on the airframe end there is a service loop which will dangle long enough to hook up the connector on the panel.

Pat

-----Original Message-----

**From:** Eric Downing  
**Sent:** April-26-13 9:22 AM  
**To:** Linda Lacelle; Patrick Smith  
**Cc:** Chris Provencal; Daryl Leger  
**Subject:** RE: D4634-045 for 139 interior

Maybe chris can answer that? I was told by Daryl that it was to be fine as is.



Eric

-----Original Message-----

From: Linda Lacelle  
Sent: Friday, April 26, 2013 9:16 AM  
To: Patrick Smith; Eric Downing  
Subject: FW: D4634-045 for 139 interior  
Importance: High

Guys??

-----Original Message-----

From: Chris Provencal  
Sent: April-26-13 9:14 AM  
To: Roberto Fuentes; Marjorie Mendoza  
Cc: Mike Petsche; Harvey Siemens; David Shepherd; Linda Lacelle  
Subject: RE: D4634-045 for 139 interior

OK. As of now, it's not sticking out the hole.

-Chris

-----Original Message-----

From: Roberto Fuentes  
Sent: Friday, April 26, 2013 8:58 AM  
To: Chris Provencal; David Shepherd; Marjorie Mendoza  
Cc: Mike Petsche  
Subject: RE: D4634-045 for 139 interior

Hi Chris,

The oblong hole is fine, I will update the drawing after we got all the input from ERA. Regarding the wire Marjorie need to check that, but I think the connector need to be out of the panel from the cut out shown in the drawing. Because the function is to quick disconnect the power from the outer panel.

Roberto

-----Original Message-----

From: Chris Provencal  
Sent: April-25-13 12:02 PM  
To: Roberto Fuentes; David Shepherd  
Cc: Mike Petsche  
Subject: D4634-045 for 139 interior

David / Roberto,

They had to oblong one of the holes to allow the connector to pass (photo.jpg). The cross-section is the same, so I OK'd the deviation.

One of the wires (D4728-049, photo2.jpg) is not sticking out past the part as shown in the dwg. The length of wire is about 34" right now (dwg says 28"), but would have to be about 42"+ to stick out as shown. I don't know if these is acceptable or not.

-Chris

-----Original Message-----

From: Eric Downing

Sent: Thursday, April 25, 2013 1:37 PM

To: Chris Provencal

Subject: Pics of wire for 139